

Work Order ID 77613

December-13-11 4:25:45 PM

77613

Page 1

Item ID: D3564-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 13/12/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/12/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog
 304 .002 Rev: D 2-Deburr if necessary

B11-12-22

14

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B11-12-22

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

S 12/21

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 Form Joggle as per Dwg D3564 on brake using Jig DT 8157	0.00 0.00				(14)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D3429	0.00 0.00				(14)			
150 *150* Large Fab Large Fab	Large Fab Memo Qty Description Batch A/R 2059B Hardcoat m120028 Weld hardcoat as per Dwg D3564	0.00 0.00				(14) MAL/LZ. 12/01/17			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		8/12/01/17					
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/12/01/17					(H4)
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 8:00 FINISH TIME: 8:30 320°F	0.00 0.00							14X0 M/L 12/01/19

M118480

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190 QC3- Inspect Part Finish 0.00

190

QC

Memo

0.00

Quality Control

14x d M 12/01/20
counted measure

200 Identify as per dwg & Stock Location: **F-P 2** 0.00

200

Packaging

Memo

0.00

Packaging

14x d M 12/01/20

210 QC21- Final Inspection - Work Order Release 0.00

210

QC

Memo

0.00

Quality Control

12/1/23

P 12-01-20 (14)

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NOTE: Date & initial all entries

Picklist Print

December-13-11 4:25:49 PM

Page 1

Work Order ID: 77613

77613

Parent Item: D3564-9

D3564-9

Parent Item Name: Wearshoe

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	150.8300	1.41	17.81053			
M304S16GA									**	13112-22			
304/316 Sheet .063													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT020		150.83					
						119653		150.83		11963	(14)		

M304S16GA

304/316 Sheet .063

(14)

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DART AEROSPACE LTD		Work Order:	77613
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.230	>		V Bo2	
2.432	+/-0.010	2.440	>		V	
2.50	+/-0.030	2.50	>		V	
6.000	+/-0.010	6.000	=		T Bo2	
12.104	+/-0.010	12.104	=		T	
18.000	+/-0.010	18.000	=		T	
18.000	+/-0.010	18.000	=		T	
18.00	+/-0.030	18.00	=		T	
9.00	+/-0.030	9.00	=		T	
11.50	+/-0.030	11.50	=		T	
0.300 x 0.300	+/-0.010	301 x 300	>		V	
Ø0.188	+0.005/-0.001	.190	>		V	
R0.375	+/-0.010	.375	=		R.G.	
0.063	+/-0.010	.059	<		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-12-22	Date: 11/12/21	Date:	N/A

Rev	Date	Change	Revised by:	Approved
A	08.01.16	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

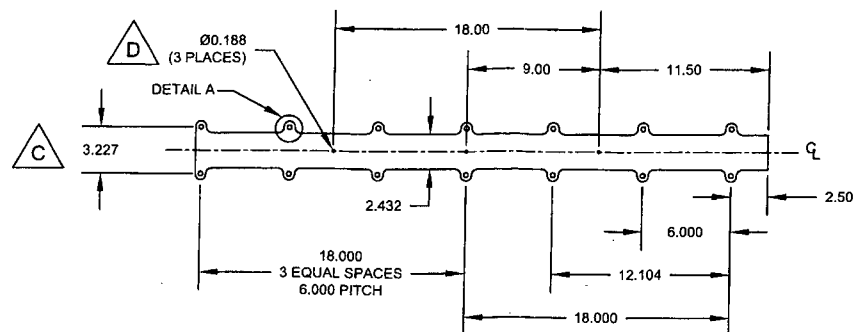
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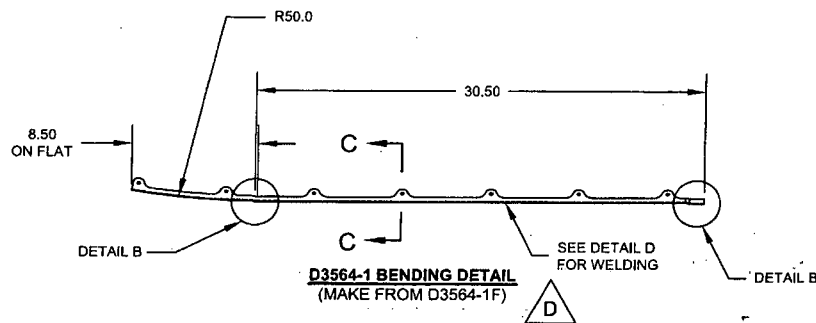
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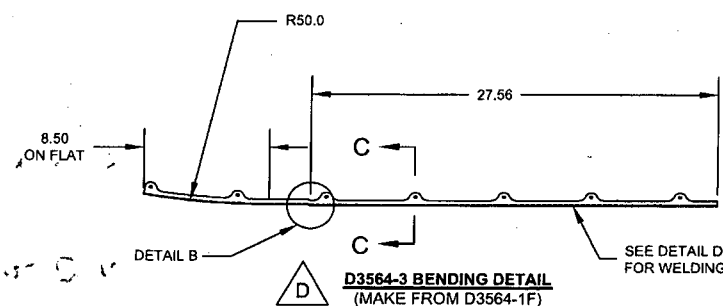
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77613 M.C.J.

1112113

RELEASED

07.09.04

UNDER REVIEW
11/10/04
Trust change
OK 11/11/04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564
REV. D
SHEET 1 OF 3

TITLE WEARSHOE
SCALE 1:8

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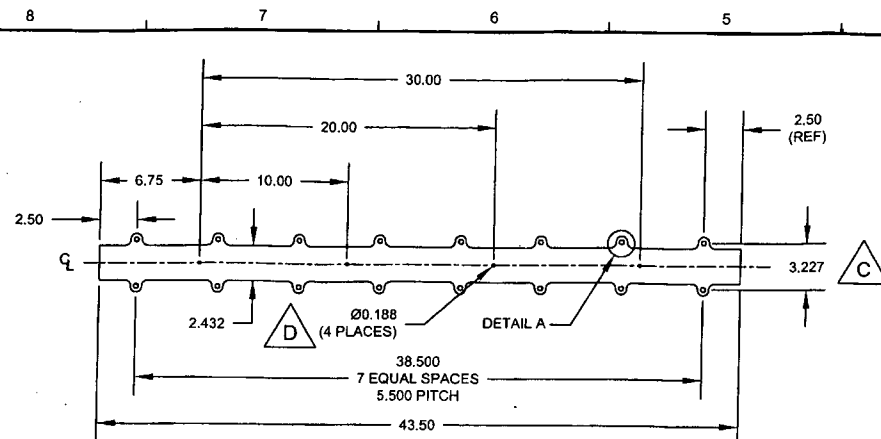
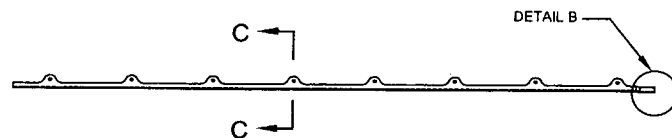
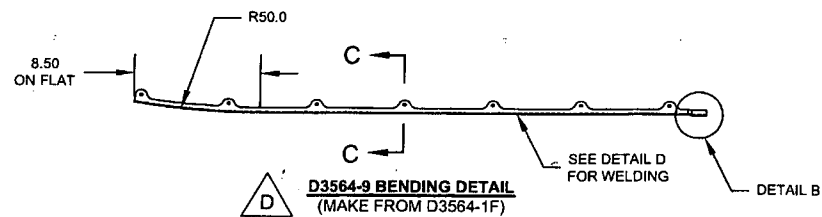
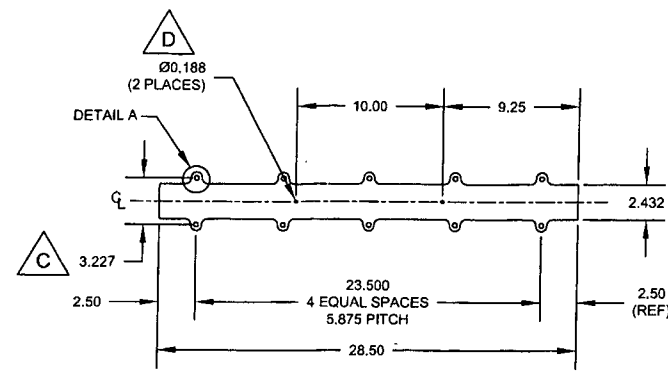
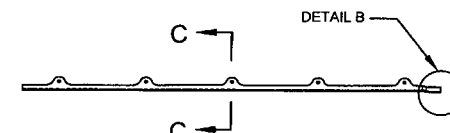
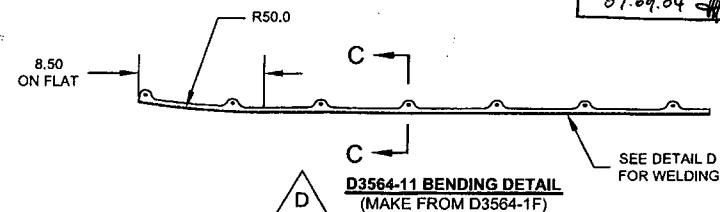
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**D3564-5F FLAT PATTERN****D3564-5 BENDING DETAIL**
(MAKE D3564-5 FROM D3564-5F)**D3564-9 BENDING DETAIL**
(MAKE FROM D3564-1F)**D3564-7F FLAT PATTERN****D3564-7 BENDING DETAIL**
(MAKE D3564-7 FROM D3564-7F)**D3564-11 BENDING DETAIL**
(MAKE FROM D3564-1F)

UNDER REVIEW
OK'd 11.11.28

RELEASED

07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CH		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR CONSUMER TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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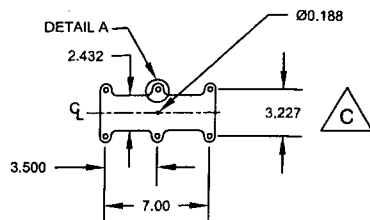
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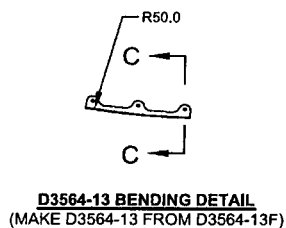
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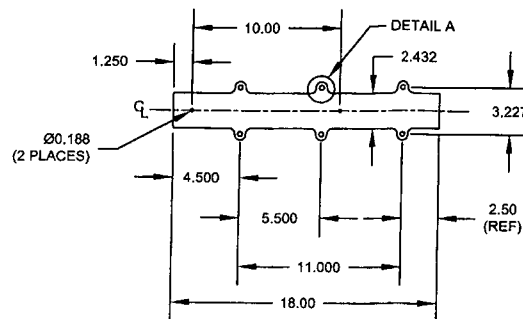
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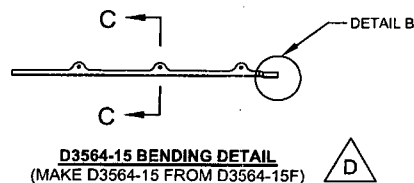
D3564-13F FLAT PATTERN



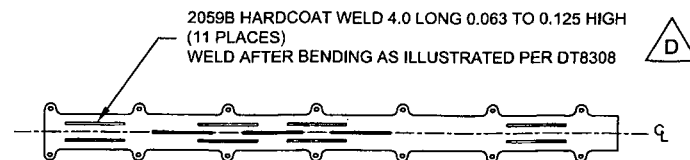
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



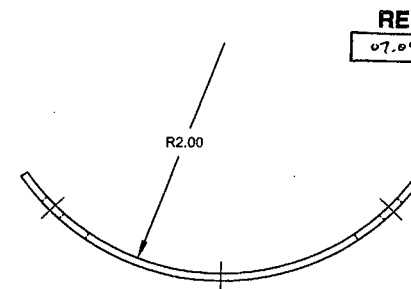
D3564-15F FLAT PATTERN



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



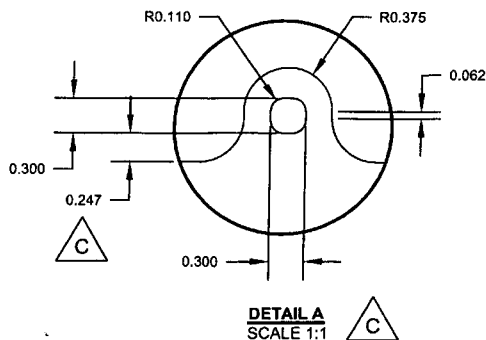
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



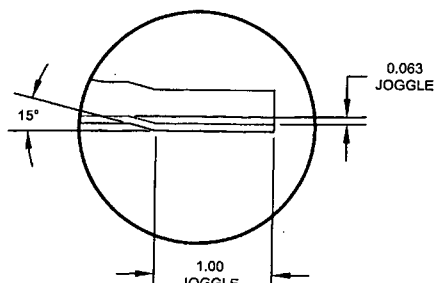
SECTION C-C
SCALE 1:1

RELEASED
07.09.04

UNDER REVIEW
OK 07.11.28



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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